

Work Order ID 166111

Monday, September 11, 2017 12:35:50 PM

166111**ASAP**

Page 1

Item ID: D3564-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Center

Start Date: 9/11/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/15/2017 Req'd Qty: 2.00

2

Customer:

Reference:

SEP 11 2017

Approvals: Process Plan:

**DAS
21**

Date:

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2**SEP 11 2017**Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3564

E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.38

FLOW CNC Waterjet

1-Cut as per Dwg D3564

Dwg Rev: **E**Prog Rev: **E**

2-Deburr if necessary

2**17/09/12****DAS
40
9-89**

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

2**17/09/12****DAS
40
9-89**

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Page 2

Item ID: D3564-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Center

Start Date: 9/11/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/15/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						<u>2</u>	<u>Ø</u>	SEP 13 2017	DAS 9 9-89
QC	Memo	0.04							
Quality Control									
130	NC BRAKE	0.13			DAS 30 9-89				
130						<u>2</u>			SEP 13 2017 MIL
Brake NC	Memo	0.24							
Brake NC	1- Deburr if necessary								
	2- Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155								
	3- Form Joggle as per Dwg D3564 on brake using Jig DT8157								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						<u>2</u>	<u>Ø</u>	SEP 13 2017	DAS 19 9-89 DAS 9 9-89
QC	Memo	0.04							
Quality Control	Ensure joggle as per dwg								

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Item ID: D3564-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Center

Start Date: 9/11/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/15/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

SprayPaint

Memo

0.00

Spray Painting

APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005
(SEE NOTE 12 ON DWG)**138351**DAS
41
9-89

SEP 14 2017

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.02

Quality Control

2**0**

SEP 18 2017

DAS
9
9-89

170

Identify as per dwg & Stock Location: **FP002**

0.00

170

Packaging

Memo

0.02

Packaging

LOCATION : FP002

(x2)**0****20170918****BER.**

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Item ID: D3564-7 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Center
Start Date: 9/11/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 9/15/2017 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.20							
Quality Control									

SEP 19 2017

DAS
21
9-89

Picklist Print

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Page 1

Work Order ID: 166111

166111

Parent Item: D3564-7

D3564-7

Parent Item Name: Wearplate Center

Start Date: 9/11/2017

Required Date: 9/15/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	84.7000	0.791	1.665263			DAS 40 9-89
M304S16GA									**		17/09/12		
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT010

84.7

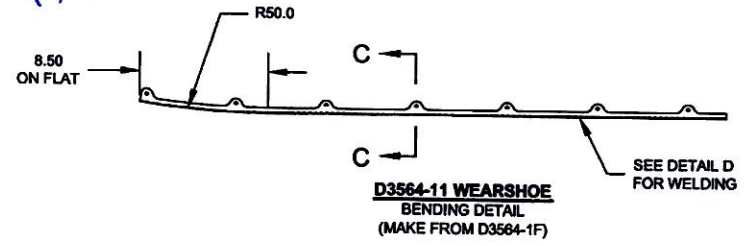
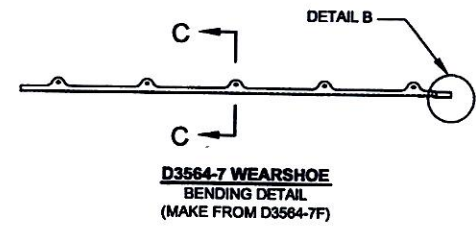
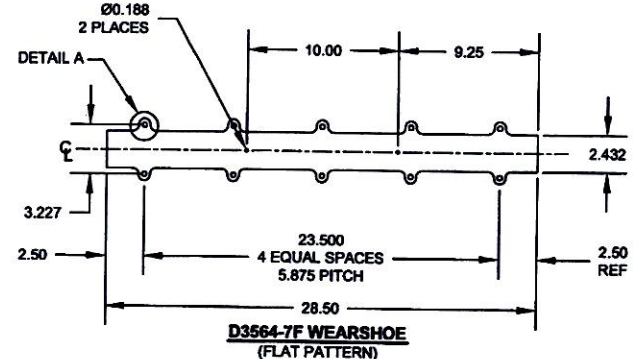
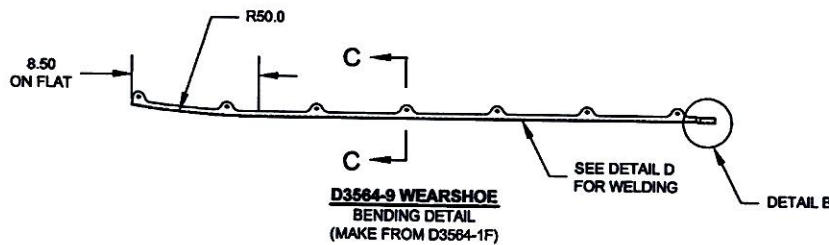
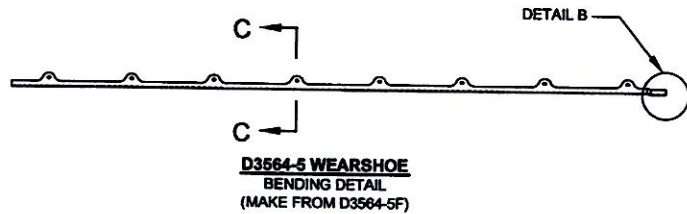
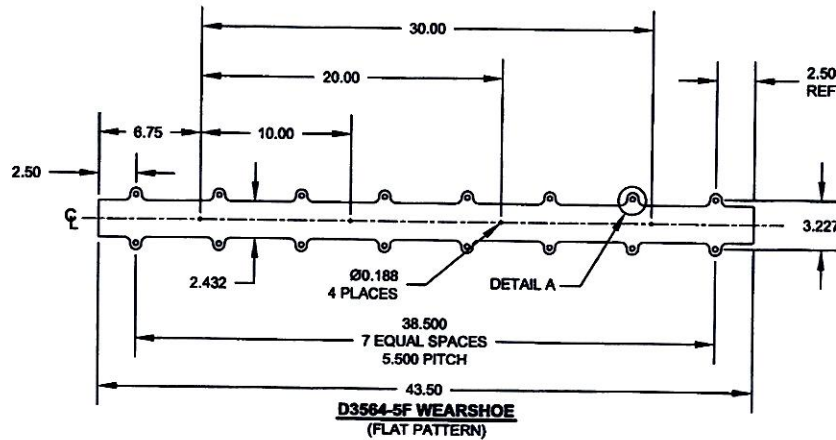
m138175

34.9

m138346

49.8

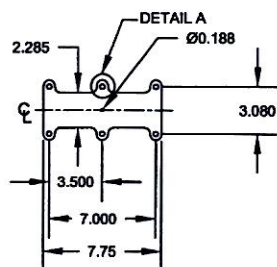
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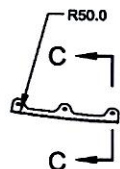
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166111 MJS
17-09-11

RELEASED
2017-04-12

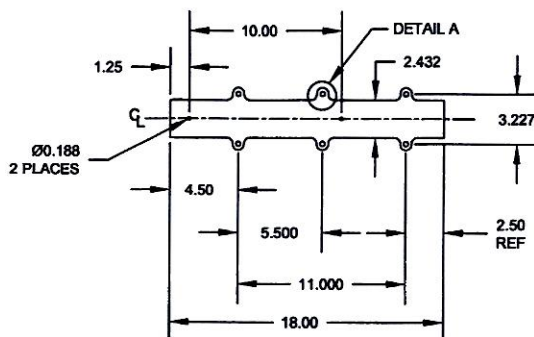
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DRAWN	SAD		
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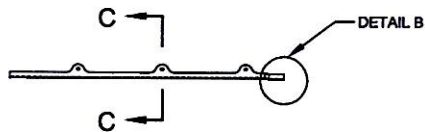
D3564-13F WEARSHOE
(FLAT PATTERN) E



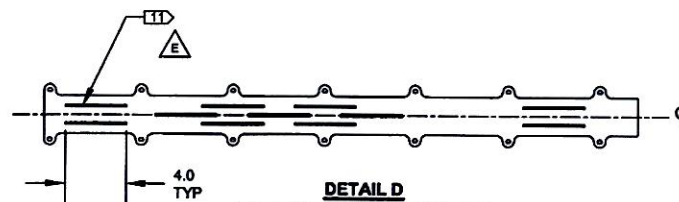
D3564-13 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-13F)



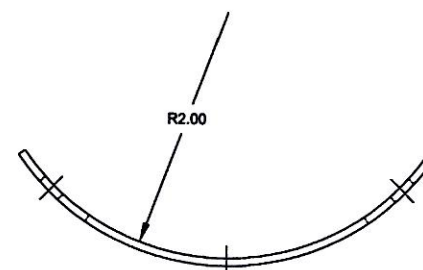
D3564-15F WEARSHOE
(FLAT PATTERN)



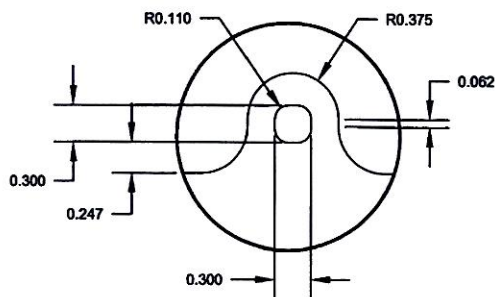
D3564-15 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-15F)



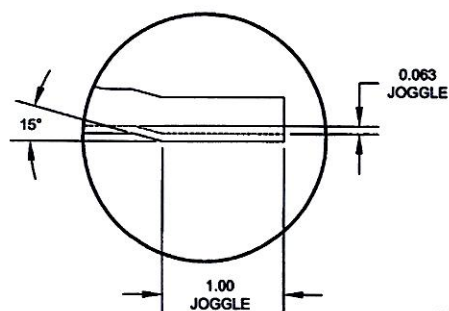
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



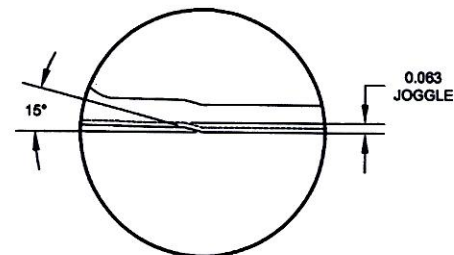
SECTION C-C
SCALE 1X



DETAIL A
SCALE 8X



DETAIL B
SCALE 8X



DETAIL E
SCALE 5X E

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